



# E3 Clearcoat

## 6801

**E3 Clearcoat #6801 is an acrylic urethane clearcoat that can be used with all solvent-based and water-based basecoats. It is suitable for automotive refinishing as well as trucks and equipment.**



### Mix Ratio

4:1 – 4 parts 6801 E3 Clearcoat to 1 part 6800 series activators  
 Can be reduced up to 10% with 6700 or 6700-F Series Urethane Grade Reducer\*.  
 Pot life: 4 hours (@70°F (21°C) and 50% R.H.).  
 \* Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.



### Suitable Substrates

- Solvent-borne basecoat
- Waterborne basecoat
- 2K enamel
- OEM finish & old paint work - non-reversible



### Surface Prep & Application

Tack thoroughly before application. For blending clearcoat refer to SOP #513 and #514.  
 Apply 2 - 3 flowing coats using the spray gun setting listed on next page. Flash for 3 – 15 minutes depending on activator used (refer to flash/dry times on next page).  
 Keep spray gun nozzle 6 - 10 inches from the vehicle to avoid entrapment of air in paint film. Always keep containers tightly closed to prevent moisture contamination. Clean equipment thoroughly after use.  
 Critical recoat time: Do not flash for more than 1 hour between coats. If more than 1 hour @ 70°F (21°C) is reached, wait at least 5 hours before applying for clearcoat or basecoat. Lightly scuff surface and degrease before application.  
 Film build: 2-3 coats @ 1.2 mils. Must have a minimum of 2.2 mils and not to exceed 3.6 mils.

### Additives

Kicker (6417) ..... Can be used at a rate of 1/2 oz per sprayable quart.  
 Appearance Improver (6487)..... Can be used at a rate of 1-2 oz per sprayable quart.  
 Fisheye Remover (6737) ..Can be used at a rate of 1/2 oz per sprayable quart.  
 Flex Additive (9194) .....Use with soft, flexible substrates. Refer to TDS for mixing information.



**Flash Times/Dry Times**

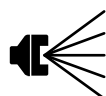
Flash between coats.....3-15 min  
 Dust free.....10-40 min  
 Dry to sand.....2-10 hrs  
 Deliver .....6-12 hrs MIN  
 Force drying.....20 min @ 140°F (60°C) without purging

Activator	Flash time	Dust free
6854/6856	3-5 min	10-15 min
6874/6876/6877	5-10 min	15-20 min
6894/6896	5-15 min	20-30 min
6894HT/6896HT/6897HT	10-15 min	20-40 min



**Gun Set-up**

Siphon feed.....1.4 - 1.6 mm Gravity feed..... 1.2 - 1.4 mm  
 Pressure feed .....1.0 - 1.2 mm HVLP/LVLP ..... 1.2 - 1.4 mm



**Air Pressure**

Siphon feed (@ gun) .....35 - 45 psi Gravity feed (@ gun) ..... 25 - 35 psi  
 Pressure feed (@ gun).....40 - 50 psi HVLP/LVLP (@ aircap)..... 10 psi

**Fluid Pressure**

Pressure feed .....8 - 10 psi



**Product Specifications**

Color.....Translucent Size.....Gallon  
 Shelf life.....3 years RTS solids by weight..... 33%  
 Approx. coverage.....510 ft<sup>2</sup>/gal @ 1 mil Weight per gallon..... 9.44 #/gal

**Regulatory**

**6801**

Category.....Clearcoat	Wt % of volatiles.....71.16
VOC actual.....0.30#/gal (35 g/l)	Wt % of water .....0
VOC regulatory.....0.91#/gal (109 g/l)	Wt % of exempt compound .....68.03
Density.....9.44 #/gal	Vol % of exempt compound .....67.37
Ready to use (less water exempt compounds)	
with 6854.....2.07#/gal (248 g/l)	
with 6874.....2.06#/gal (247 g/l)	
with 6894.....2.07#/gal (248 g/l)	
with 6894HT .....2.07#/gal (248 g/l)	

**6854/6856**

Category.....Clearcoat	Wt % of volatiles.....46.98
VOC actual.....3.50#/gal (419 g/l)	Wt % of water .....0
VOC regulatory.....3.64#/gal (419 g/l)	Wt % of exempt compound .....5.20
Density.....8.37 #/gal	Vol % of exempt compound .....3.91

**6874/6876/6877**

Category.....Clearcoat	Wt % of volatiles.....49.93
VOC actual.....3.40#/gal (407 g/l)	Wt % of water .....0
VOC regulatory.....3.72#/gal (446 g/l)	Wt % of exempt compound .....11.00
Density.....8.73 #/gal	Vol % of exempt compound .....8.62

**6894/6896**

Category .....	Clearcoat	Wt % of volatiles.....	46.20
VOC actual .....	3.52#/gal (422 g/l)	Wt % of water .....	0
VOC regulatory .....	3.63#/gal (435 g/l)	Wt % of exempt compound .....	4.00
Density .....	8.34 #/gal	Vol % of exempt compound .....	3.00

**6894HT/6896HT/6897HT**

Category .....	Clearcoat	Wt % of volatiles.....	46.20
VOC actual .....	3.50#/gal (419 g/l)	Wt % of water .....	0
VOC regulatory .....	3.65#/gal (438 g/l)	Wt % of exempt compound .....	5.50
Density .....	8.59 #/gal	Vol % of exempt compound .....	4.25



**Limitations & Precautions**

- Visit [www.tat-co.com](http://www.tat-co.com) to assure use of the most current instructions and TDS on this product.
- See website ([www.tat-co.com](http://www.tat-co.com)) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.

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